Quality Control

NCR:	Yes	/ No				WORK ORDER NON-	COI	VFOR	MANCE / UP	DATE			
										i de la companya de	QA Closed:	Date:	
Nork Ord	er:					DISPOSITION	_			AGAINST DE	PARTMENT		
						Rework			Skid-tube	Crosstube	_	Water Jet	Engineering
Part	No.					Scrap		i .	Machining	Small Fab		d. Eng. Coor.	Quality
						Use-as-is	_	Thern	noforming	Finishing	Rec/Stor	e/Packaging	Other
NCR	No.					Work Order Update	_ ل		Large Fab	Composite]	Supplier	
Root					Descr	iption of work order update		Initial	Ac	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
oc/Data													
quip/Tooling	L												
perator	╙												.
laterial	L												
etup	L												
ther	<u></u>		·										,
rocess	┖								•			:	
upplier	L												
raining													
napproved	<u> </u>												
							AUL	T CATE	GORY				
Landi	ng (Gear				General	_				_		-
	L	Bending				Bend		Grain			Ovalized		Pressure/Forced
	L	Centre No	t Concer	ntric to (o/s	_BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorred	ct	Weld
		Crushed/0	Crimped.	•	L	Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved		
	—					Countersink		Mislabe	eled		Positioned V	Vrong	_
		Inspection	Strip in	Tube		Cut Too Short		Misread	i		Power Loss/	Surge	Other
		Ripples in	Bend			Drill Holes		Offset					
		Torque W	aves in E	xtrusior	,	Drawing		Out of 0	Calibration				
		Turning Se				Finish		Out of S	Sequence				
		Wave/Twi	ist in Tub	e		Folio		Outside	Dimensions				

DQA:

Date:

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Work Ord November-19-1.				·	*9341	13*						-	Page 2	2
Item ID: Revision ID: Item Name:	647.1711 Plate				Accept	*N900	<u>040</u>	100)*	Setup	Start Stop	171.	S1* S2*	
Start Date: Required Date: Reference:	11/19/12 : 12/07/12	Start Qty: 12.00 Req'd Qty: 12.00		*12* *12*		Cust Item ! Customer:	ID:							
Approvals:		an:		*****	Tooling: SPC (Y/N):		ate:				Start Stop		R1* R2*	
Sequence ID/ Work Center I 130 *130* QC Quality Control	D	Operation Description QC8- Inspect parts - seco	nd check		Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp	SA
*140 *140* Brake NC Brake NC		Form as per dwg Memo			0.00				12					3/01/
150 *150* QC Quality Control		QC5- Inspect part comple	eteness to sto	ep on W/O	0.00 SW) 0.00 13.1-18	.			<u>[]</u>	· ·		·		

									DQA:	Date:	,
NCR: Y	es / No				WORK ORDER NON-O	CONFORM	MANCE / UPI	DATE			4
					· · · · · · · · · · · · · · · · · · ·	T			QA Closed:	Date:	
Work Orde	ar.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap Use-as-is	- 1	Skid-tube Machining noforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Initial	Act	ion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Descr	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling									ļ		
Operator											
Material											
Setup									·		
Other						-					
Process		1									
Supplier											
Training											
Unapproved											
					F.	AULT CATE	GORY				
• Landin	ng Gear				General				_		_
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre No	ot Concer	ntric to (o/s	BOM/Route	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed/	Crimped.			Burrs	Instruct	ions Incomplete/U	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	nance		Part Moved	. —	_
	Heat Trea	it			Countersink	Mislabe	led		Positioned V	V rong	
	Inspection	n Strip in	Tube		Cut Too Short	Misread	l		Power Loss/	'Surge	Other
	Ripples in	Bend			Drill Holes	Offset			-		- · · · · · · · · · · · · · · · · · · ·

Out of Calibration

Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Work Orden				*93	413*							Page 3
Item ID: Revision ID: Item Name:	647.1711 Plate			Accept	*N900	040	100)* s	Setup	Start Stop	*N:	S1* S2*
Start Date: Required Date: Reference:	11/19/12 : 12/07/12	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item II Customer:	D:					14.	
Approvals:		an:	Date:	_ 0		ite:		I	Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 160 *160* Outsource4 Outsource process		Operation Description Outsource process-Anodi Memo ISSUE P/O: HARD ANO	.0261	Set Up/ Run Hours 0.00 0.00		Tool #	Plan Code	Accept Qty	Rej Qty	, I	Reject Number 1 13 - A	Insp. Stamp
170 Packaging Packaging		Receive & Inspect for Da Memo	mage & Mat'l Certs	0.00			l	У х			<u> </u>	8P-9
180 *1 2 0* QC		QC5- Inspect part comple	eteness to step on W/O	0.00 37	e) 1-9			12				

Quality Control

												DQA:	Da	te:	,
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE		•			
												QA Closed:	Da	te:	
Work Ord	۵r·					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS		
Part I	No.	-				Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verificatio	n	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
							AUL	T CATE	GORY						
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea Inspection	Crimped. it n Strip in		o/s	General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misreád	on Incomplete ions Incomplete/ nance led	Unclear		Ovalized Over/Under Part Incorre Part Lost/Mi Part Moved Positioned V	ct issing Vrong		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	Inspection Strip in Tube Ripples in Bend					Drill Holes		Offset							

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

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Work Ord November-19-1.				*934	113*						Page 4
Item ID: Revision ID: Item Name:	647.1711 Plate			Accept	*N900	040	100)* s	Setup Sta	1.7	S1* S2*
Start Date: Required Date: Reference:	11/19/12 : 12/07/12	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item ? Customer:	ID:					
Approvals:		lan:	Date:	Tooling: SPC (Y/N):	10.0 10.0 20.0 10.0 10.0	ate:		F	tun Sta Sto	I V	R1* R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 SprayPaint Spray Painting			MIL-P-23377J TYPE1 C 4860-50 PRIMER BATC		(SEE NOTE 3)			17		13-0	4/M/ ×5-5
*200 *200* QC Quality Control		QC14- Inspect Spray Pair Memo		0.00 3 10	5/B				-		
*210 *210*		Identify as per dwg & Sto	ock Location: 57 5V	0.00				13x			S
Packaging Packaging		Memo ***IDENTIF	Y AS PER APICAL MPP	0.00 -120 BY STAMPING Pa	# AND REV***						13-5-

												DQA:	Da	ate:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	MANCE / UPI	DATE	,	DA Classid.			
					-							QA Closed:	Da	ate:	
Work Ord	er.					DISPOSITION				AGAINST DI	EP.	ARTMENT/	PROCESS		
Work Ord	C1.					Rework	7		Skid-tube	Crosstube	٦		Water Jet		Engineering
Part	No.					Scrap	1	1	Machining	Small Fab	1	Proc	d. Eng. Coor.	\vdash	Quality
,			· · · · · · · · · · · · · · · · · · ·			Use-as-is	1	1	noforming	Finishing	1		e/Packaging	_	Other
NCR	No.					Work Order Update	1	1	Large Fab	Composite	7	•	Supplier	_	
Root				į	Descri	ption of work order update	Ι.	Initial	Act	ion	T	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ct	nief Eng	Descr	iption	\perp	Date	Verification	ın ·	QC Inspector
Doc/Data														i	
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Training	<u> </u>	Į.													
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							AUI	T CATE	GORY						
Landing Gear					_	General		1		_	_			_	1
	Bending				.	Bend	<u></u>	Grain		ļ	-	Ovalized		-	Pressure/Forced
	Centre Not Concentric to O/S				^{O/S} _	BOM/Route	-	Hardwa		<u> </u>	-	Over/Under		-	Temperature/Cure
	Cracks					Broken/Damaged	_	4 `	on Incomplete	-	-	Part Incorrec		<u> </u>	Weld
	Crushed/Crimped.					Burrs			ions Incomplete/L	Jnclear	-	Part Lost/Mi	ssing		Wrong Stock Pulled
	_	Cuffs			\vdash	Contamination		Mainte		<u> </u>		Part Moved			
	<u> </u>	Heat Trea			<u> </u>	Countersink	_	Mislabe			-	Positioned W	_	_	7
	١.	Inspection	n Strip in	Tube	-	Cut Too Short	[.	Misread	1		F	Power Loss/S	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

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Work Orde				*934	113*	,						Page 5
Item ID: Revision ID: Item Name:	647.1711 Plate			Accept	*N900	040	100)*	Setup	Start Stop	ı VI .	S1* S2*
Start Date: Required Date: Reference:	11/19/12 12/07/12	Start Qty: 12.00 Req'd Qty: 12.00	*12* *12*		Cust Item I Customer:	D:						
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:			Run	Start	17	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:				Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	-	Reject Number	Insp. Stamp
*220 *27 *20 *20 QC Quality Control		QC21- Final Inspection - Memo	Work Order Release	0.00						3/5	5/13 MF	99
											13	-513

				DQA:	Date:	J	-
NCR:	Yes /	No	WORK ORDER NON-CONFORMANCE / UPDATE				18

							•		QA Closed:	Date	•
Work Orde	er.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N				.,	Rework Scrap	7	Skid-tube Machining	Crosstube Small Fab	Pro	Water Jet	Engineering Quality
raici	•0				Use-as-is	- The	rmoforming	Finishing	-1	re/Packaging	Other
NCR N	No		<u>.</u>		Work Order Update	_ '''	Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	Initial	А	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Er	g Des	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
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Training											
Unapproved											
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Landi	ng Gear				General				_		_
	Bending				Bend	Grain	1		Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspe	ction Incomplete		Part Incorre	ct	Weld
	Crushed,	/Crimped.			Burrs	Instru	ictions Incomplete	:/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mair	tenance		Part Moved		
	Heat Tre	at			Countersink	Misla	beled		Positioned V	Wrong	_
	Inspection	on Strip in	Tube		Cut Too Short	Misre	ad		Power Loss/	/Surge	Other
	Ripples i	n Bend			Drill Holes	Offse	t				
	Torque V	Vaves in E	xtrusio	n [Drawing	Out o	f Calibration				
	Turning S	Sequence			Finish	Out o	f Sequence				

Outside Dimensions

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

November-19-12 10:03:33 AM

Work Order ID:

93413

Parent Item:

647.1711

Parent Item Name:

Plate

Start Date: 11/19/12

Required Date: 12/07/12

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A 12.10.05 NEW ISSUE DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Status Issued	_
M7075T6S.160		Purchased	No				sf	48.0000		13.844211		Jmr	-1D-4
7075-T6 Sheet .160										14.0	* 11.0 C	OWEVZ	= 1 K(/

 Location
 Loc Oty
 Loc Code

 MAT
 48

 123644
 48

23644

												DQA:	Date:	
NCR:	Yes	/ No					WORK ORDER NON-C	100	NFORI	MANCE / UPDATE			· · · · · · · · ·	
												QA Closed:	Date	
Nork Ord	er:						DISPOSITION			AGAINST	DEP	ARTMENT	PROCESS	
Part							Rework Scrap		1	Skid-tube Crosstube Machining Small Fab		Prod	Water Jet	Engineering Quality
NCR							Use-as-is Work Order Update		Thern	noforming Finishing Large Fab Composite		Rec/Stor	e/Packaging Supplier	Other
Root					Desc	rip	tion of work order update		Initial	Action		Sign &	<u>·</u>	
Cause		Date	Step	Qty		0	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector
oc/Data														
quip/Tooling														
perator	<u> </u>													
laterial	<u> </u>													
etup	<u> </u>													
ther	<u> </u>							ŀ						
rocess	<u> </u>													
upplier	┕													}
raining	<u> </u>													
napproved			<u> </u>		<u></u> .									
								AUL	T CATE	GORY				
Land	ng (1			_	_	General	_	1	r				٦
		Bending					Bend		Grain		_	Ovalized		Pressure/Forced
	<u></u>	Centre No	ot Concer	ntric to	o/s		BOM/Route		Hardwa	re	\dashv	Over/Under		Temperature/Cure
	L	Cracks				_	Broken/Damaged	L	1 '	on Incomplete		Part Incorred		Weld
	Crushed/Crimped.						Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	ssing	Wrong Stock Pulled
		Cuffs			L	\Box	Contamination		Mainte	nance		Part Moved		
	L	Heat Trea	it				Countersink		Mislabe	led		Positioned W	/rong	
	L	Inspection	n Strip in	Tube			Cut Too Short		Misread	j [Power Loss/S	Surge	Other
		Ripples in	Bend				Drill Holes		Offset					
		Torque W	aves in E	xtrusio	n [Drawing		Out of 0	Calibration	_			
		Turning S	equence		Γ		Finish		Out of S	Sequence	_			

Outside Dimensions

Wave/Twist in Tube

•	,						
•	ENGINEERING	CHANGE NOTIC.	, NO.	02937	İSH	IEET . [lf i
APICAL	DWG NO. 647	1700 REV: NC	PREPARED,	JACKSON DA	ATE: 07/14/	10 EFFECT	ON EV.G
INDUSTRIES, INC.	DWG TITLE:	SKID DEFLECTE	JR ASSY		4.0		
	APPROVED BY ENGR	3re MFG	200 B	- Maure	J. Berger EF	F: CURRENT [JRDER
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVISE	D F/N 8 AND NOTE	<u> </u>	INSPECTION D	DIMENSIONS TO	DRAWING '	VIEWS.
SHEET 1, ZONE AL]	<u>IS:</u>			SHE	EET 2.	4.15	7
(PRETREAT PRC-DE	BDIZE IAW MIL-A-8625 ESOTO PR-148 ADHESIG -23377J TYPE I CLAS	I TYPE HI CLASS 2.65 DN PROMOTER, COLOR BI	LOR BLACK; LUE;	<u> Z01</u>	NE A1 IS:		
				SHOP CORETURN ENGINEER UNCONTROLLISUBJECT TO AMI WITHOUT NO. WORK OR NO. 934	FO ENG ED COPY ENDMENT OTICE DER	A	
8 R 601.1622	1 SCREW				MS2703	39-1-14 /	<u>/</u>
	QTY DESCRIPTION				MATER	IAL/SPECIFI	CATION
DOCUMENTS EFFECTED:	□ MDL □ INSTALL	INSTRUC FMS	ICA ⊠ BOM	CHANGE CATEG⊡F □ MAJ□R ⊠ MIN	RY DER REVIE IOR O YES	W REQUIRED	

NOTE: MATERIAL: 7075-T6 ALUMINUM PER AMS-QQ-A-250/12 MATERIAL: 6061-T6 ALUMINUM BAR IAW AMS-QQ-A-250/11 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III CLASS 2. COLOR BLACK: CARDINAL 4860-50 PRETREATMENT PRIMER: PRIME IAW MIL-P-23377 J TYPE I CLASS N 4. DEBURR AND BREAK ALL SHARP EDGES IDENTIFY IAW MPP-120 CLAMP F/N 1, 2, & 4: THEN MATE AND MATCH DRILL HOLES FROM F/N 1 & 2 ONTO F/N 3 AS SHOWN ON SHEET 2. -⑤ 22 PL

2 PL (6)

UNINCORPORATED ECN(s)

02937

O	TY			PARIS UST		
L	.1701	FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
	> <		647.1701	SKID DEFLECTOR ASSY		
		1	647.1710	PLATE		B
1_	1	2	647,1711	PLATE	\triangle	Δ
	1	3	647.1712	GUSSET	\triangle	Δ
	i	4	647.1713	SPACER	À	Δ
	22	- 5	601,1915	RIVET	C.F.3213-4-4	
	2	- 6	601.1607	WASHER	NAS1149F0332P	
	1	7	601.2943	LOCKNUT	MS21C42-3	
1	1 1	8	601.2637	SCREW	M507009-1-13	

OTY

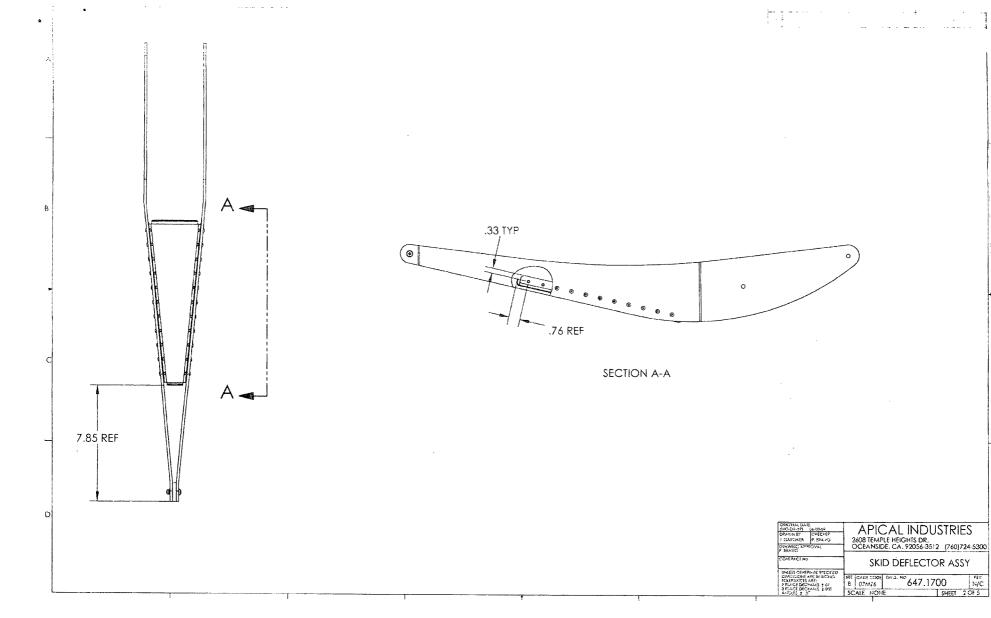
NEXT ASSY (S)

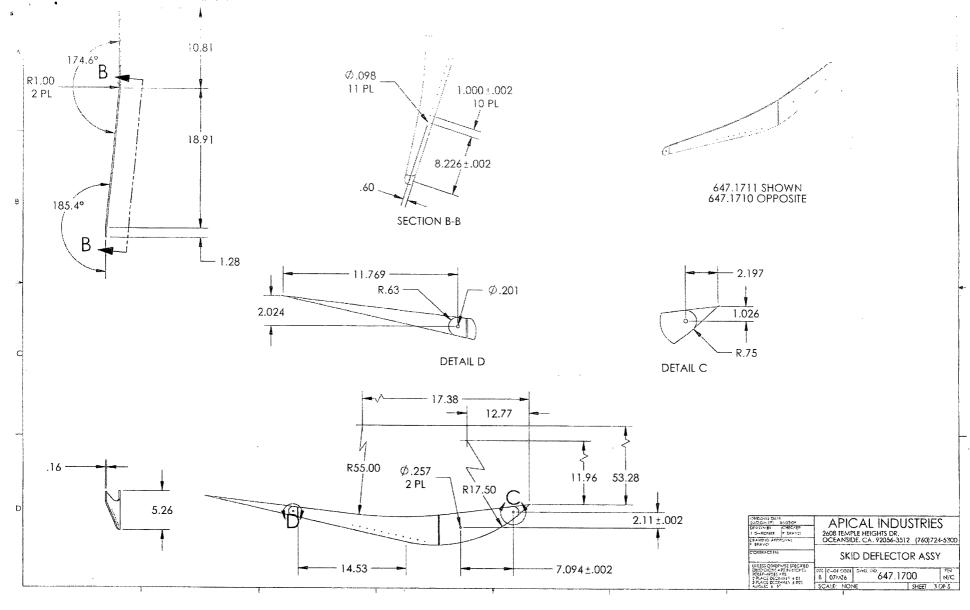
647.1300

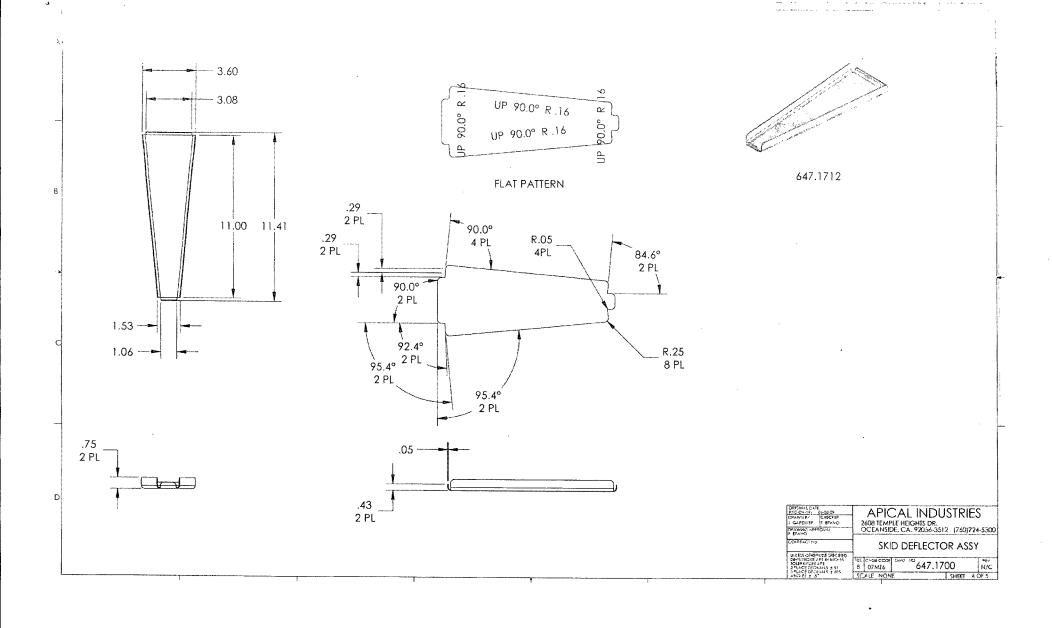
CHECKER DESTRUCTION

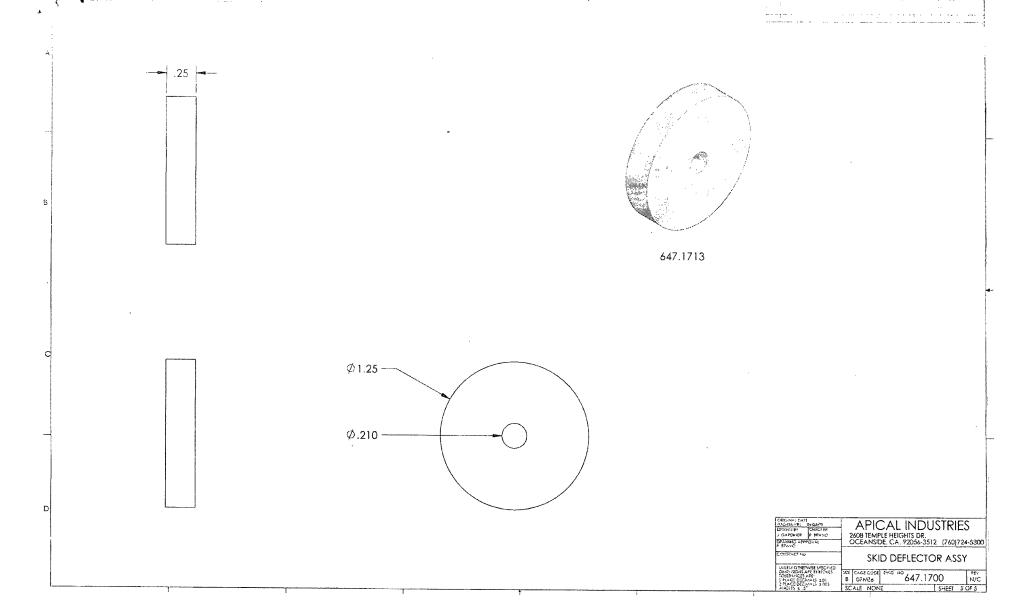
APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300

SKID DEFLECTOR ASSY









DART AEROSPACE LTD	Work Order: 92412			
		13973		
Description: Plate	Part Number:	647. 1711		
Inspection Dwg: (という、コロロ Rev: ハ/と		Page 1 of 1		

FIRST ARTICLE INSPECTION CHECKLIST

Prawing Actual Method of							
Dimension	Tolerance	Dimension	Accept	Reject	Method of Inspection	Comments	
Ø 0.098°	10.004"	0,101"			U	Jkmoi	
Ø 0.201.	110.005	0.205	_		V		
Ø0.253".	10.006"	0.260	_	e.	· U	14	
1,000	+1-0.002"	1.002	_		V		
0.60	+1-0.010"	0.607	_		V	4.	
2.11		2.11	•		U	4	
1.020	11.0.005	1.026"	_		V		
2.197"	1/0.005"	2.197"			v	ζ,	
0.160	+1-0.000°	D.161"		·	✓	*1	
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·		Bathy or 1	na.			e e	

Measured by:	Jm
Date:	·Q-12-4

Audited by:	/ 85 89
Date:	12/205

I	Preliminary Approval:	
į	Date:	



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62300

Date: 08-Apr-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

erms		Ship Via			
Quantity	Description				
1	Part: ASST		Rev:		
lol		. ·			
	24 PCS 647.1711				
	15 PCS 647.1712 31 PCS 647.1910				
	8 PCS 647.1911				
	5 PCS 647.7911				
:	12 PCS 647.1710				
• .	HARD ANODIZE BLACK	rg etc		•	
4	MIL-A-8625 TYPE III CLASS 2				
	Job: 20130197	PO: 19280	Line:		
	Certificate of C	conformance			
	A.T.G. Industries certifies that all item with all requirements, specifications a	ns in this shipment are in coi	ntormance ne purchase order.		
'	ISO 9001 : 2008 R ATG SALES-2010	REGISTERED TERMS APPLY			
	a/N/12				
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